

Process Sheet

Date: Tuesday, 12/12/2006 10:31:49 AM
User: Kim Johnston

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LEFT ARM WELDMENT
Job Number : 29902
Estimate Number : 12080
P.O. Number :
This Issue : 12/12/2006 S.O. No. :
Prsht Rev. : NC Part Number : D33543
First Issue : 1/1 Type : MACHINED PARTS Drawing Number : D3354 REV. A
Previous Run : 27658 Drawing Revision : A
Written By : Due Date : 1/10/2007 Qty: 20 Um: Each
Checked & Approved By :
Comment : est rev A 06.01.23 new issue EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M4130NR1250 4130N ROUND BAR



Comment: Qty.: 0.6300 f(s)/Unit Total: 12.6000 f(s)

AISI 4130 ROUND BAR 1.250" dia. batch: M103090 → 11.34 f
M18490 → 1.26 f

Control work and finish in case of

J.F 07/1/03

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: 1-TURN AS PER FOLIO FA623 & DWG D3354

FOLIO REV: Δ

DWG REV: Δ

2-DEBURR AS REQUIRED

J.F 07/1/03

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F 07/1/03

4.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1-Drill cotter pin hole as per dwg D3354

2-Debur

J.F 07/01/04

J.F 07/01/03

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F 07/01/03

ac

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Drawing Name: LEFT ARM WELDMENT

Job Number: 29902

Part Number: D33543

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *W523*

Epl 07.01.04

(20)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.01.05

Job Completion



11 07.01.05

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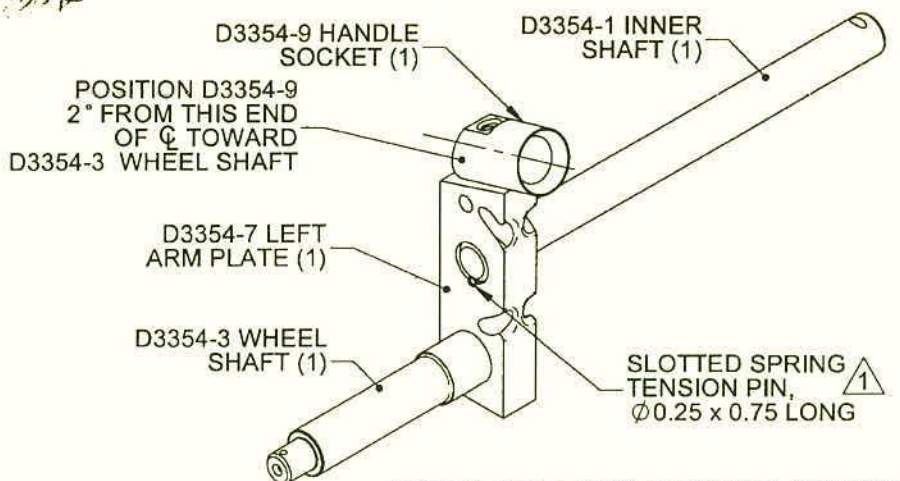
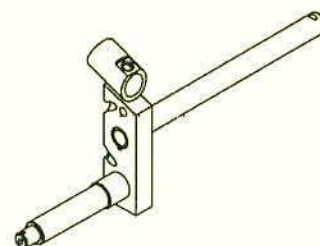
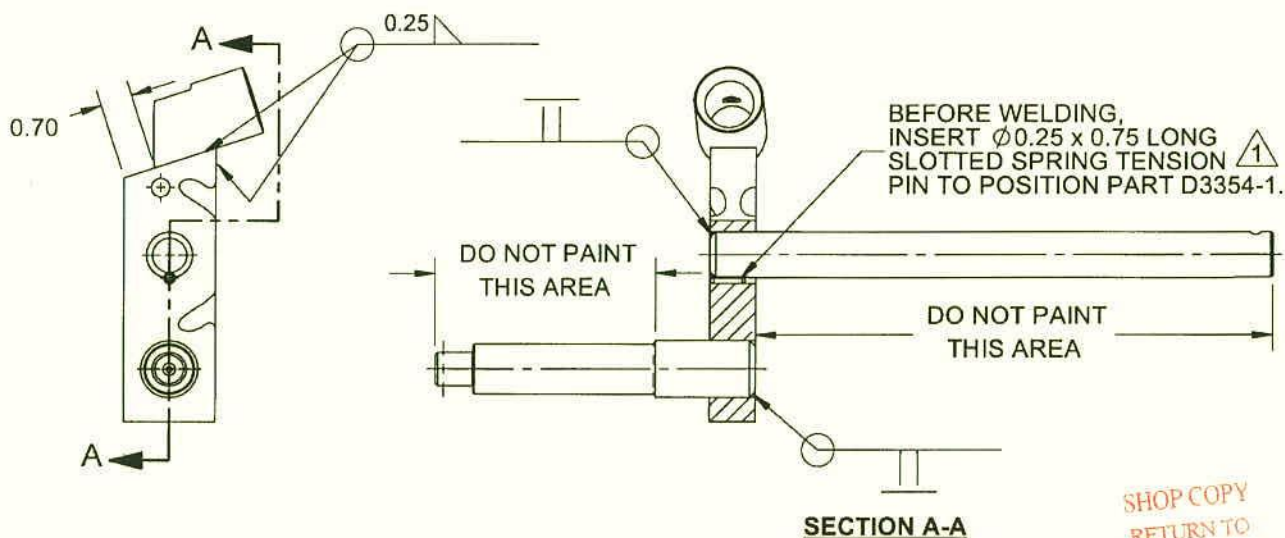
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DART

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CHECKED 13	APPROVED	DRAWING NO. D3354	REV. A SHEET 1 OF 7
DATE 04.12.13		TITLE LEFT ARM WELDMENT	SCALE 1:4
A	04.12.13	NEW ISSUE	

RELEASED
06/02/14**D3354-041 LEFT ARM WELDMENT****D3354-042 MIRROR ARM WELDMENT****NOTES:**

- 1) POSSIBLE SUPPLIER: SPAENAUR, P/N TP-134
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

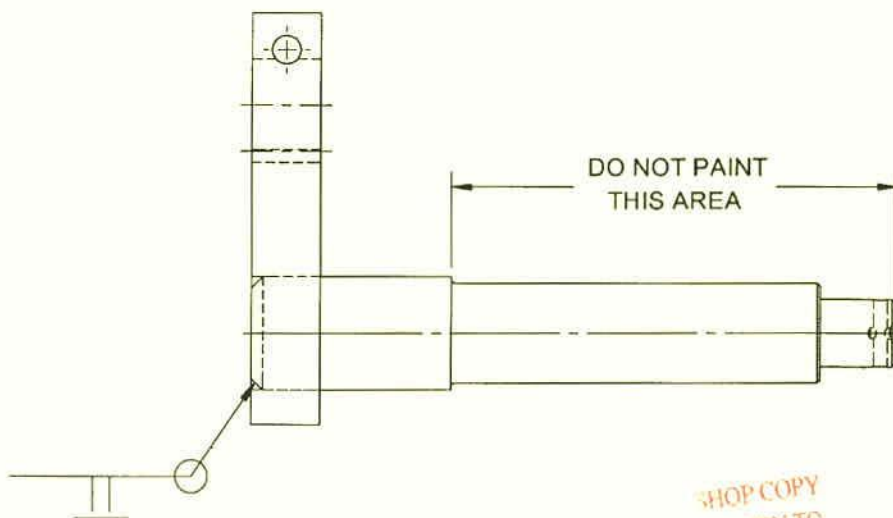
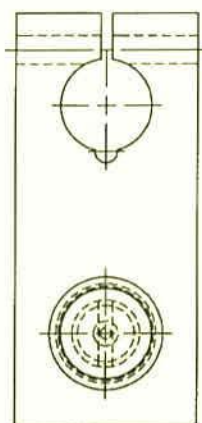
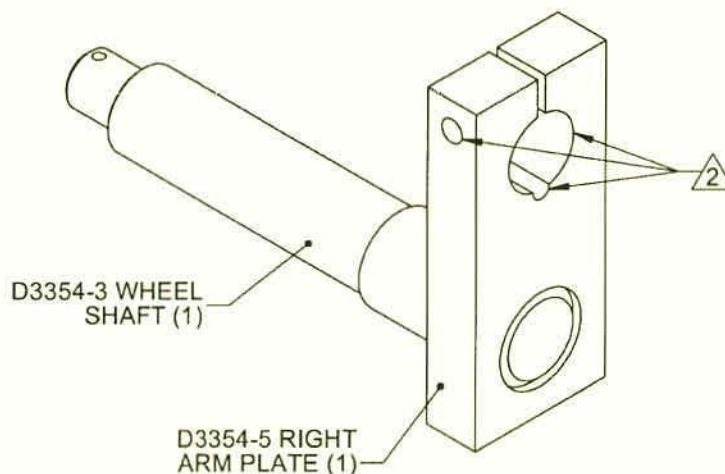
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DATE 04.12.13	TITLE LEFT ARM WELDMENT		SCALE 1:2

RELEASED
06/03/14
[Signature]**D3354-043 RIGHT ARM WELDMENT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

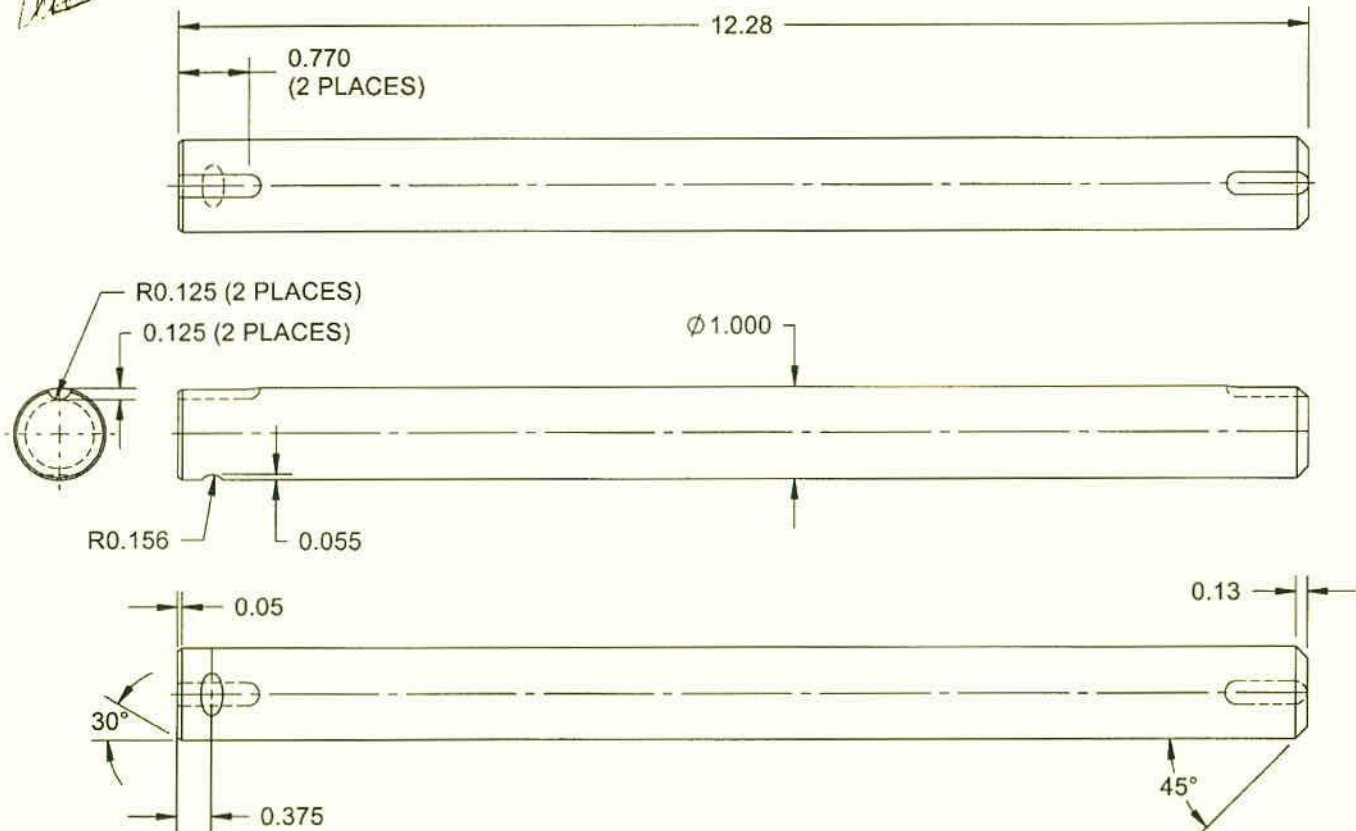
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DATE 04.12.13		TITLE LEFT ARM WELDMENT	SCALE 1:2

RELEASED
06/03/01
[Signature]**D3354-1 INNER SHAFT**

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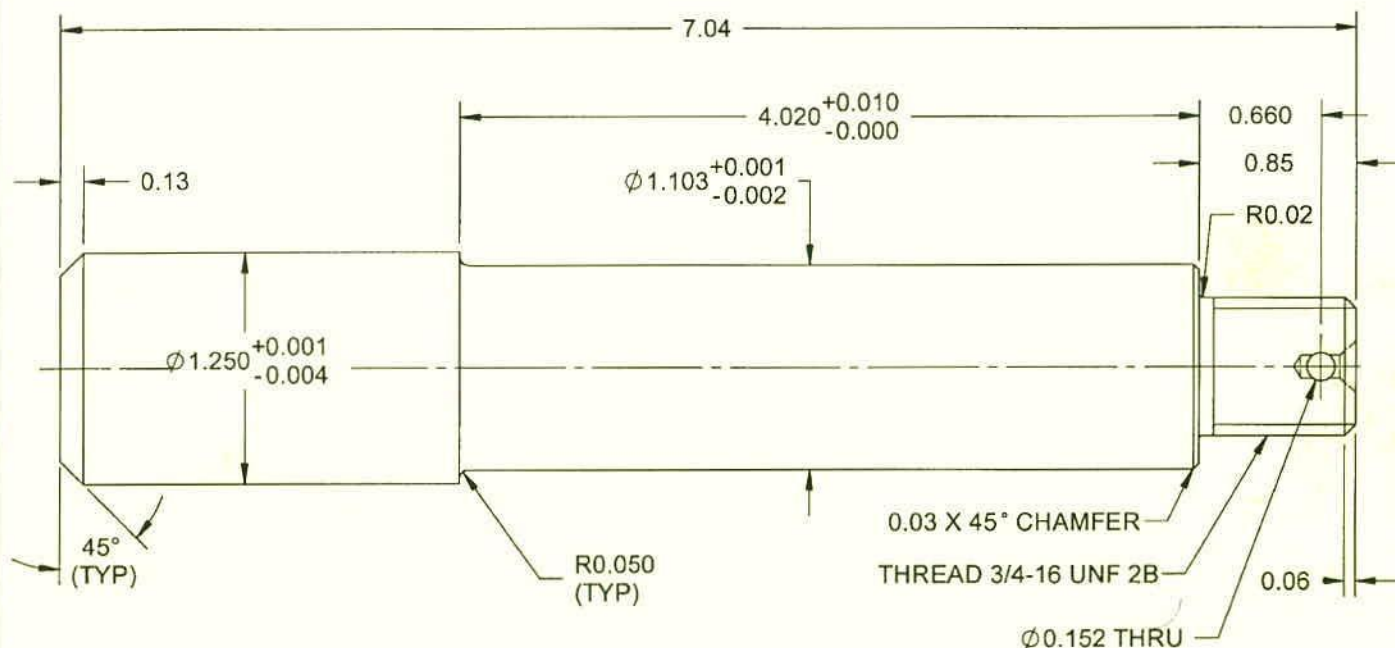
- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91
OR UNS#-G41400 ROUND BAR, $\phi 1.250$ (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 04.12.13	TITLE LEFT ARM WELDMENT		SCALE 1:1

RELEASED
[Handwritten: 06/01/14]**D3354-3 WHEEL SHAFT****NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, $\phi 1.250$ (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

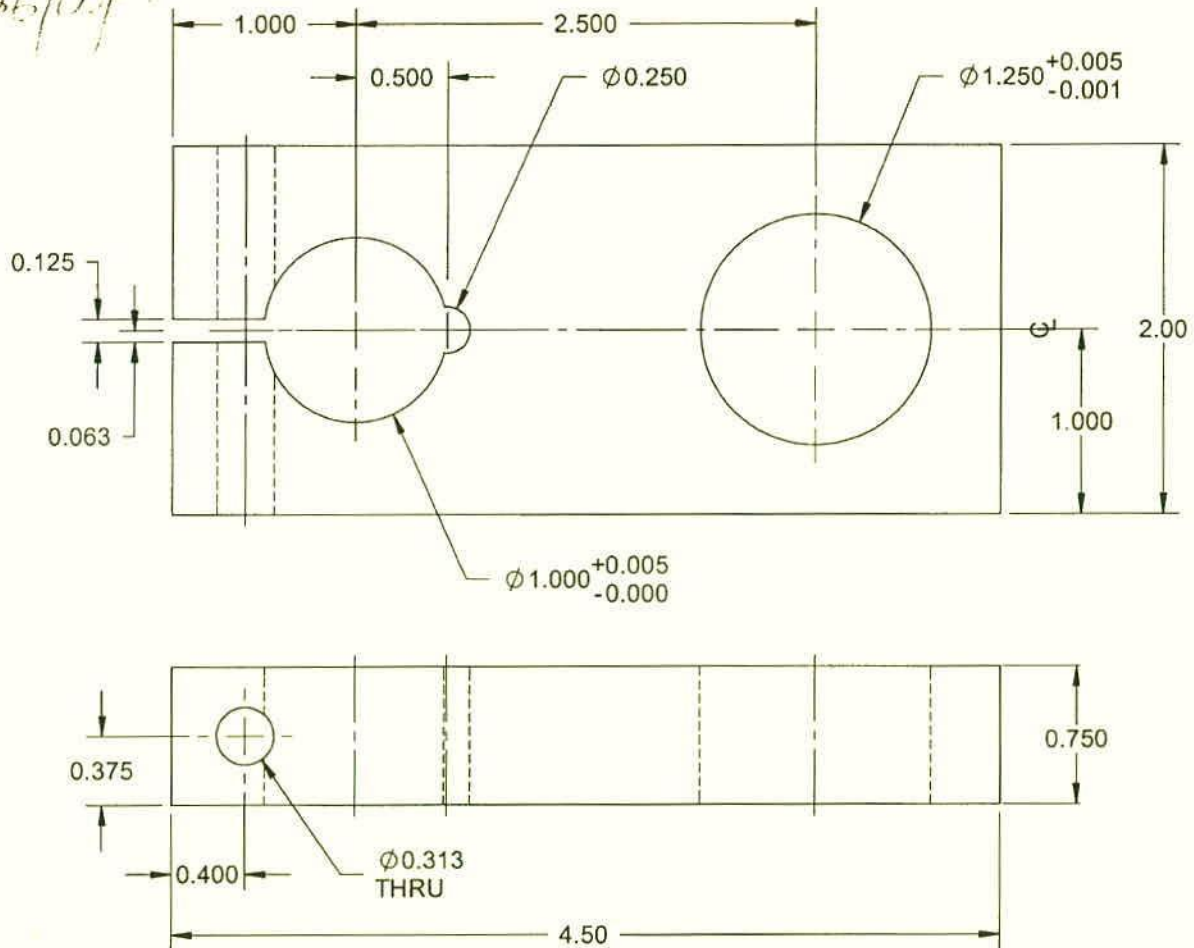
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DATE 04.12.13	TITLE LEFT ARM WELDMENT		SCALE 1:1

RELEASED
26/03/14**D3354-5 RIGHT ARM PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

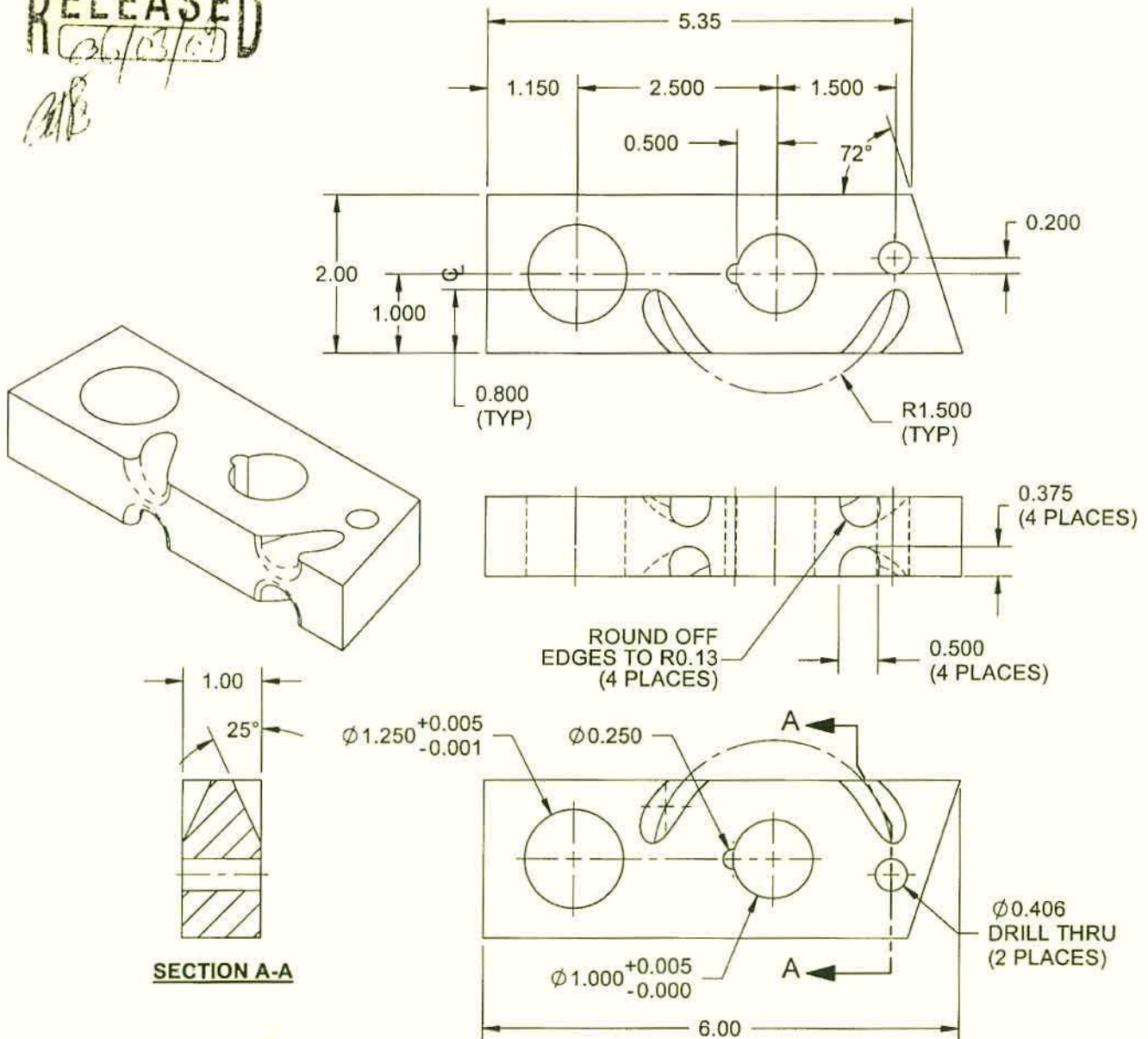
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DATE 04.12.13	TITLE LEFT ARM WELDMENT		SCALE 1:2

RELEASED
26/03/09
[Signature]**D3354-7 LEFT ARM PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.00 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

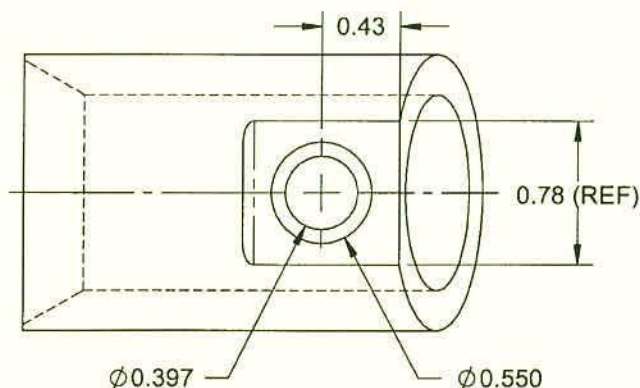
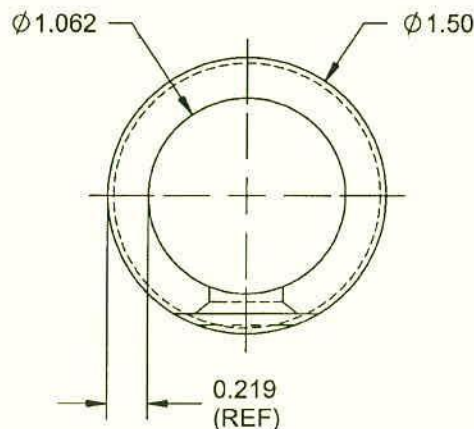
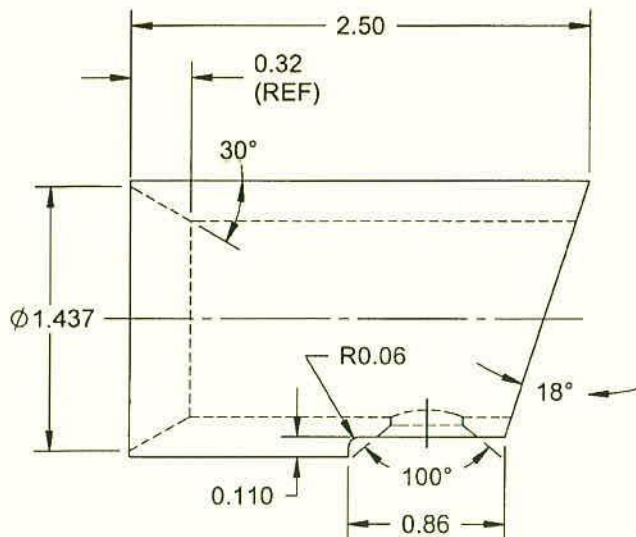
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DATE 04.12.13	TITLE LEFT ARM WELDMENT		SCALE 1:1

**D3354-9 HANDLE SOCKET****NOTES:**

- 1) MATERIAL: AISI 1010-1025 SEAMLESS ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, (REF. DART SPEC. M1020TR1.250W.219)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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